WOIR CITUELID /331	ork Order ID 733	Order ID 7331	7
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Page 1

Wednesday, August 31, 2011 10:50:16 AM

Item ID:

D3536-39

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Gasket

9/1/2011

Start Qty: 20.00 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 9/15/2011

Process Plan: MF

Date: //- 09-0/ Tooling:

Date:

Start



Date:

1.

SPC (Y/N):

Date:

Stop

Stop



Sequence ID/ Work Center ID Draw Nbr

Operation Description

Revision Nbr

Set Up/ Run Hours Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

D3536

Waterjet

Rev A

100

FLOW WATER JET

0.00

0.00

1311-9-28

FLOW CNC Waterjet

□Prog Rev: |

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

QC8- Inspect parts - second check

Memo

0.00

B 11-9-28

Quality Control

120

Quality Control

Dart Ae	rospace	Ltd								· • •
W/O:			WO	RK ORDER CHA	ANGES					
DATE	STEP	PRO	OCEDURE CHAP	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
									-	
Part No):	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQ	A:	Date: _	
	Resolution:		Disposition	Disposition: Q			QA: N/C Closed:			
NCR:			WORK ORD	ER NON-CONFO	RMANC	E (NCR)			
DATE	OTED	Description of NC		Corrective Action	Section B		Verification		Approval	Approv
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date		ion C	Chief Eng	QC Inspect
							_			

Work Order ID 73317



Page 2

Item ID:

D3536-39

Wednesday, August 31, 2011 10:50:16 AM

Accept

Setup Start

Stop



Revision ID:

Start Date:

Required Date: 9/15/2011

Item Name:

Gasket

9/1/2011 **Start Oty: 20.00**

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:_____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Run Start



Stop

Insp.

Sequence ID/

Work Center ID

130

Packaging

Operation Description

QC: ____

Reg'd Oty: 20.00

Identify as per dwg & Stock Location:



Run Hours

0.00

Set Up/

Code

Qty

Reject

Accept

Qty

Number Stamp BK 11-9-29

Tool ID

0.00

Packaging

140

QC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

Memo

0.00

Reject

M/10/3 TX) MF 11-09-29

W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cated	orv:	NCR: Yes	No DQA :		Date:	
Resolution:									
NCR:				R NON-CONFORMA					
		Description of NC		В	Verifica	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspecto
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Picklist Print

Wednesday, August 31, 2011 10:50:13 AM

Work Order ID: 73317

Parent Item:

D3536-39

Parent Item Name: Gasket



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	583.5500	0.7534	16.74222 (B	11-9-3	8	

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code	
MAT052	583.55		
117295	55.68		
118026	127.87		
118663	400] [



W/O:	T. T		WO	RK ORDER CHAN	IGES					,
DATE	STEP	PRO	OCEDURE CHAN			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	NCF	R: Yes I	No DQ	A:	_ Date: _	
		esolution:								
NCR:		,	WORK ORDE	R NON-CONFORM	MANCE	(NCR)			
DATE	CTED	Description of NC			ection B		Verific	cation Approval		Approval
DATE	SIEP	STEP Section A	Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Secti		Chief Eng	QC inspector
	,									
					•					
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DART AEROSPACE LTD	Work Order:	~75511
Description: Gasket	Part Number:	D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35,71			T 1881	
32.78	+/-0.030	35,78			7	
29.28	+/-0.030	86.96			7	
25.78	+/-0.030	><.78	X		T	
23.25	+/-0.030	23,24	<u></u>		7	
19.75	+/-0.030	1974	4		7	
17.75	+/-0.030	17.75	80		7	
14.25	+/-0.030	14.25	4		7	
9.50	+/-0.030	9.50	χ		τ	
4.75	+/-0.030	4.75	×		7	
5.00	+/-0.030	00,2	ъ		7	
9.00	+/-0.030	9.00	N		7	-
0.30	+/-0.030	.304	8		V BOZ	
0.30	+/-0.030	1305	2		V	
1.88	+/-0.030	1.885	¥		V	
Ø0.19	+0.005/-0.001	,190	*		V	
0.063	+/-0.010	,061	8		V	
	· 					

Measured by:	B	Audited by:	0	Prototype Approval:	N/A
Date:	11-9-38	Date:	ulab9	Date:	N/A

Rev	Date	Change	Revised by	Approxed
Α	07.03.14	New Issue	KJ/JLM	
				

3		
Dart Ae	rospace	Ltd

_ ~	Jopase								*
W/O:			WO	RK ORDER CHANGE	ES				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval A	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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1 OF 6 REV.

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DRAWING NO. D3536

96 DATE

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GASKET

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06.10.25

NEW ISSUE

B.62.12

26.65 21.15 17.65 13.40 - 0.90 - 5.65 -1.89 3.90 DETAIL A Ø0.19

D3536-11 GASKET

14.00

32.90	
29.40	
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18.98	
14.07	
9.15	0.90
- 5.65 -	
	1 1
	1.89
DETAIL A	
60.19	
(TYP 4 PLS) 20.00 14.00 20.00	

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)

(TYP 3 PLS)

- 2) FINISH: NONE
 3) PART IS SYMMETRICAL ABOUT Q
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

D3536-13 GASKET

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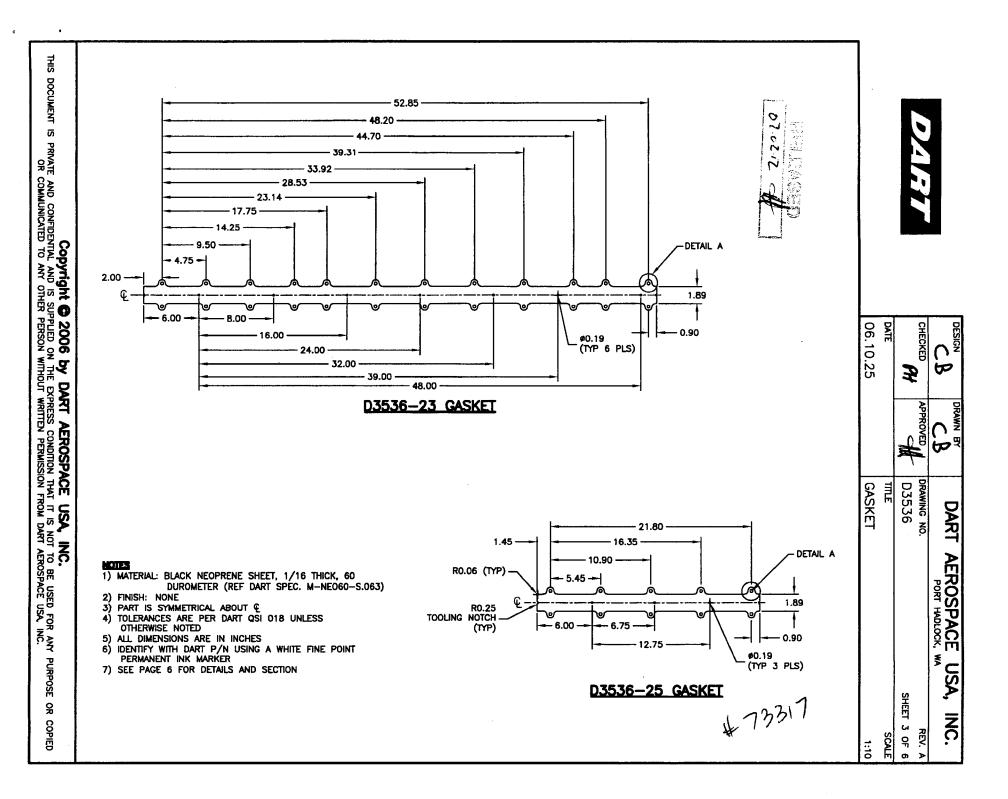
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NCR:		·	WORK ORD	ER NON-CONFORM	ANCE (NCR)		
DATE	OTED	Description of NC				Verification	Approval	Approval
DAIE	SIEP	Section A				Section C	Chief Eng	QC Inspector
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W/O:			W	ORK ORDER CHANG	ES					
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Resolution:		Disposition: G			Close	ed:		Date: _		
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sect Action Description Chief Eng		ın & ate	Verific Section		Approval Chief Eng	Approval QC Inspector
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DATE	STED	Description of NC				Verifica	tion	Approval	Approval
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06.10. DATE

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AEROSPACE PORT HADLOCK,

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PURPOSE

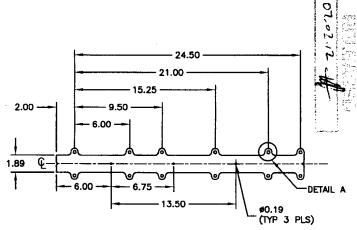
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19.00 2.00 -- 6.00 → 1.89 Q-DETAIL A 6.00 ≠0.19 (TYP 3 PLS) D3536-31 GASKET



D3536-33 GASKET

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- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

23.25	1
19.75	
17.75	
1.89 £ 6.00 6.75 \$\\ \text{\$\psi_0.19}{\psi_0.19} (\text{TYP 2 PLS})	DETAIL

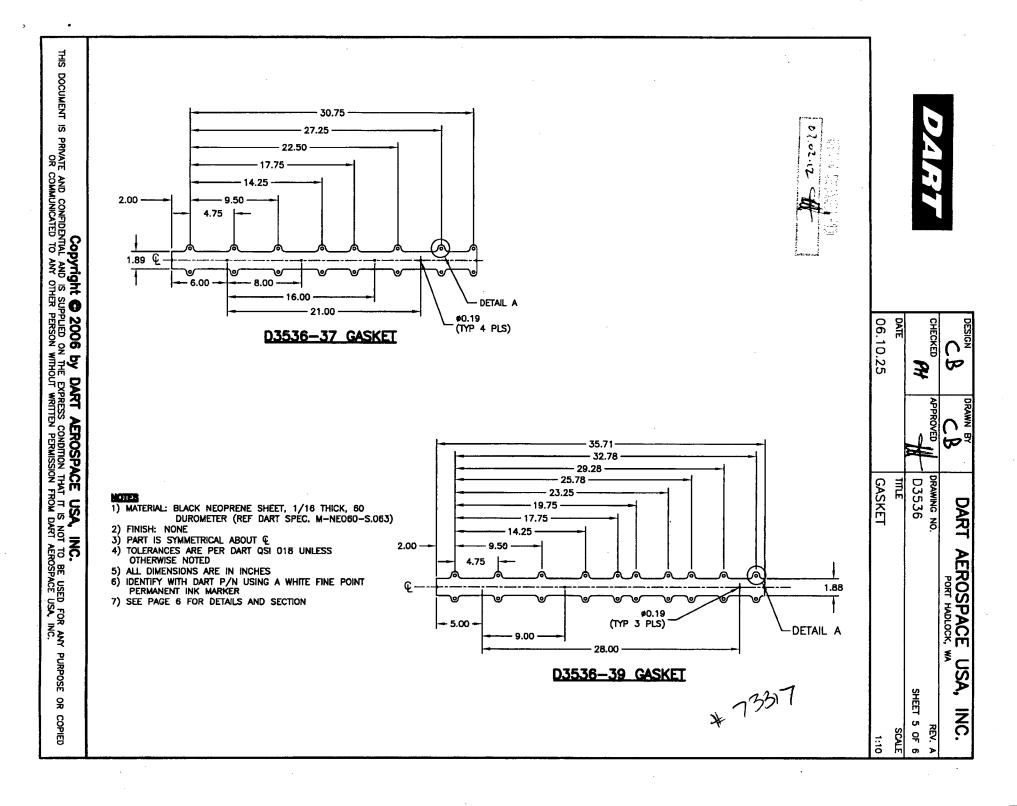
D3536-35 GASKET

 			
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Part No: _	PAR #	: Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief EngAction Description Chief EngSign & Date		Section C	Chief Eng	QC Inspector			
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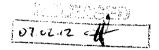


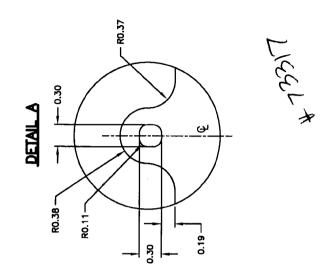
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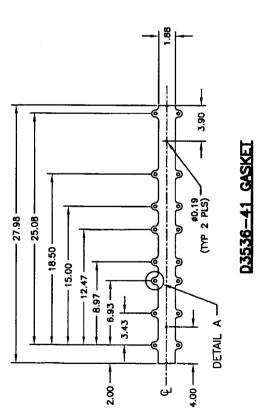
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
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	PH	I III	D3536	SHEET 6 OF 6
1	DATE		TITLE	SCALE
	06.10.25		GASKET	1:10







MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60
DUROMETER (REF DART SPEC. M—NEO60—S.063) FINISH: NONE
PART IS SYMMETRICAL ABOUT ©
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES
PERMANENT INK MARKER ଅଧ୍ୟ

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:		Date:

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DATE		Description of NC	Corrective Action Section B			Verification	Approval	Approval		
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		